

Work Order ID 48151

July 1, 2009 8:46:22 AM



Page 1

Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, LH, AS350

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-600-241
CHG 001

Handwritten: Hfa CL 09/07/09 Sorkster

110

0.00



Small Fab

Small Fab

Memo

1-Drill holes in D3188-1 using drill jig Dt8970
2-Open holes in D3188-1 body floor to 0.297" as per dwg D3188
3-Deburr
4-Install inserts in D3188-1 as per dwg D3188

0.00

Handwritten: FT 09-07-20

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

Handwritten: => Sorkster

Handwritten: (40)

Handwritten: 6

Work Order ID 48151



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Item ID: D350-600-241

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Item Name: Spacepod, LH, AS350

Start Date: 07/15/2009 Start Qty: 1.00



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Reference:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Memo

0.00

1-Cut D2986 Neoprene Foam per template D2986T1

N/A Pulled under B48237

cut on waterjet

140

0.00



Small Fab

Memo

0.00

*** this step seperates hardware, previous steps is for baody & floor***

u 09.07.24

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Item ID: D350-600-241

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Start Date: 07/15/2009 Start Qty: 1.00

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y

1-drill and plug section I-I and J-J of dwg D3188 p. 11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: 110970

xpiry date: Dec-04-09

A/R Milled fibers batch: 100859

2-Attach Neoprene Foam using Contact cement

A/R Contact cement Batch: 112225

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

IT 09-07-20

=> 5 09/07/21

Ⓢ

Work Order ID 48151

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Accept

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Start Date: 07/15/2009 Start Qty: 1.00

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Wing Walk as per dwg QSI005 4.4 Batch *7/11/03*

0.00

WMD 09/07/21

(X1)

HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

BR 09-07-21

QC

Memo

0.00

Quality Control

190

QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

SD 09/07/22

(10) f

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Item ID: D350-600-241

Accept



Setup Start



Revision ID: C

Stop



Item Name: Spacepod, LH, AS350

Start Date: 07/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 08/03/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-600-141

Location: _____

PPP rev: _____

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/7/22 C
09/07/24 JF

mf
09-07-24

Picklist Print

Page 1

July 1, 2009 8:46:20 AM

Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350







Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3188-1MRevE		Manufactured	No			110	Each	0.0000	1.0000			
										45711A	CU	
SPACEPOD BODY LH												
D3186-3RevD		Manufactured	No			110	Each	0.0000	1.0000			
										45711B	CU	
Spacepod Door, LH												
D3187-1RevC		Manufactured	No			110	Each	12.0000	1.0000			
										31835	B31835	CU
Spacepod Floor												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

31835

1

37196

11

31835

CU

ALS4-1032-130

Purchased

No

110

Each

7,849.000 28.0000



Insert



9/7/14

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7849

110511

7849

110511

CU

Picklist Print

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Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
A3235-020-935  Washer - Countersunk		Purchased	No			110	Each	815.0000	8.0000		9/7/14	SL


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	815	
104156	59	
106150	756	

104156

D2986-1RevB  Rubber Spacer		Manufactured	No			130	Each	6.0000	1.0500			
---	--	--------------	----	--	--	-----	------	--------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
48237	6	

48237

D3015-3RevB  Locknut		Manufactured	No			140	Each	435.0000	1.0000		9/7/14	SL
---	--	--------------	----	--	--	-----	------	----------	--------	--	--------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	435	
43758	26	
44446	50	
48238	359	

48238

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Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3554-7RevA

Manufactured

No

140

Each

81.0000

1.0000



Ball Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

81

37674

81

D3567-1RevA

Manufactured

No

140

Each

29.0000

1.0000



Decal

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

37311

9

48254

20

9/7/14 SP
PC

37674

37311

PC 9/7/12

Picklist Print

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Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516  Washer		Purchased	No			140	Each	1,603.000	1.0000		9/7/14	SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1603
100564	2
106167	6
107534	34
107959	43
108246	46
108672	2
109059	49
109752	22
110363	46
110523	57
111279	296
112082	1000

D2237RevD1

Manufactured

No

140

Each

30.0000

2.0000



Striker Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	30
46162	30

Picklist Print

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Parent Item Name: Spacepod, LH, AS350



Comments:

Start Date: 07/15/2009



Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-5		Purchased	No			140	Each	7,958.000	4.0000			
											9/7/14	SP
Rivet												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7958	
4067	1141	
6733	1835	
6874	4982	

D3538-1RevA		Manufactured	No			140	Each	40.0000	2.0000			
											9/7/14	SP
Hinge Bracket												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
44650	9	
46753	12	
48197	19	



Picklist Print

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Parent Item Name: Spacepod, LH, AS350



Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2179RevB  Doubler		Manufactured	No			140	Each	95.0000	2.0000 		9/11/14	SL

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	95	
30630	1	
35432	94	

30630
35432

AN526C832R24  screw		Purchased	No			140	Each	144.0000	4.0000 		9/12/14	SL
--	--	-----------	----	--	--	-----	------	----------	---	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	144	
104603	44	
110179	100	

104603

①

Picklist Print

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Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD8



Washer

Purchased

No

140

Each

1,143.000

4.0000



85 09-07-20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1143

107091

9

108335

11

110382

48

110917

75

111578

1000

xy

MS21042L08



Nut

Purchased

No

140

Each

306.0000

4.0000



85 09-07-20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

306

110002

24

111889

282

112243 x4

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Shop Packet Print

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Picklist Print

July 1, 2009 8:46:21 AM

Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350



Comments:

Start Date: 07/15/2009



Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-08-11		Purchased	No			150	Each	139.0000	2.0000			
											9/7/14	SP
Screw												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	139	
104427	6	
108335	33	
111977	100	

AN960JD8		Purchased	No			150	Each	1,143.000	16.0000			
											9/7/14	SP
Washer												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1143	
107091	9	
108335	11	
110382	48	
110917	75	
111578	1000	

111578

2

Picklist Print

July 1, 2009 8:46:21 AM

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Parent Item Name: Spacepod, LH, AS350


Comments:

Start Date: 07/15/2009


Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3  Washer		Purchased	No			150	Each	530.0000	2.0000		9/7/14	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	530	
109268	261	
110397	108	
111268	161	

MS21042L08  Nut		Purchased	No			150	Each	306.0000	14.0000		09-07-20	RT
--	--	-----------	----	--	--	-----	------	----------	---------	--	----------	----

MISSING
this

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	306	
110002	24	
111889	282	

D2464RevB  3/4 Seal		Manufactured	No			150	f	896.4300	11.3400		09-07-20	RT
--	--	--------------	----	--	--	-----	---	----------	---------	--	----------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	896.43	
39669	112.58	
48173	783.85	

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Shop Packet Print

Picklist Print

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Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3567-1RevA

Manufactured

No

150

Each

29.0000

1.0000



Decal

87 07.07.20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

37311

9

48254

20

D2586RevD

Manufactured

No

150

Each

80.0000

2.0000



Door Latch

9/7/14 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

80

23082

0

45554

1

47183

79

D2585RevB

Manufactured

No

150

Each

22.0000

2.0000



Mounting Channel

47183

9/7/14 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

45888

22

45888

(K)

Picklist Print

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Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350


Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2621RevB  Latch Plate, 350 Spacepod		Manufactured	No			150	Each	91.0000	2.0000		9/7/14	SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

41175

46842

91

⑤ Resto

86

41175
46842

MS27039-1-15

Purchased

No



Screw

150

Each

116.0000

2.0000



9/7/14

SP

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

106903

108169

109321

110915

111916

116

3

4

4

5

100

111916

⑩

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Parent Item Name: Spacepod, LH, AS350


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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10  Washer		Purchased	No			150	Each	1,246.000	2.0000		9/17/14 SQ	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1246	
105442	95	
109059	2	
109840	23	
110985	202	
111279	13	
111668	911	

MS21042L3  Nut		Purchased	No			150	Each	1,873.000	2.0000		9/17/14 SQ	
---	--	-----------	----	--	--	-----	------	-----------	--------	--	------------	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1873	
110844	34	
111274	839	
111668	1000	

Picklist Print

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Comments:

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Required Date: 08/03/2009

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-1RevB  Hinge Bracket		Manufactured	No			150	Each	30.0000	1.0000		9/17/14	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	30	
41166	7	
45788	23	

D2857-2RevB  Hinge Bracket		Manufactured	No			150	Each	38.0000	1.0000		9/17/14	SP
---	--	--------------	----	--	--	-----	------	---------	--------	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	38	
43363	12	
45797	26	

D2228RevB  Bracket Plate		Manufactured	No			150	Each	120.0000	4.0000		9/17/14	SP
---	--	--------------	----	--	--	-----	------	----------	--------	--	---------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	120	
30679	73	
48228	47	

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Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350



Comments:

Start Date: 07/15/2009



Required Date: 08/03/2009

Start Qty: 1.00



Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R10		Purchased	No			150	Each	195.0000	10.0000			
											9/7/14	SP
Screw												

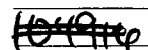
Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	195	
104603	195	

D3557-1RevA		Manufactured	No			150	Each	18.0000	1.0000			
											9/7/14	SP
Bracket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	18	
32647	7	
46887	11	

AN526C832R14		Purchased	No			150	Each	1,051.000	2.0000			
											9/7/14	SP
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1051	
104916	1051	

M 107285

 10

Picklist Print

July 1, 2009 8:46:22 AM

Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

K10021RevN/A

Manufactured

No

190

Each

5.0000

1.0000



Spacepod Hardware Kit (-241)

Print

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

5

41361

2

47217

2

48266

1

47217 1x *Lo*

D350-600-449RevC

Manufactured

No

190

Each

7.0000

1.0000



Switch Relocation

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

7

41358

4

47203

3

41358 (1x) *24/7/22*

D2985RevA1

Manufactured

No

190

Each

19.0000

1.0000



Label

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

19

41341

4

48236

15

48236 (1x) *24/7/22* (2)

July 1, 2009 8:46:22 AM

Shop Packet Print

Picklist Print

July 1, 2009 8:46:22 AM

Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350



Comments:

Start Date: 07/15/2009


Required Date: 08/03/2009



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3547-1RevA		Manufactured	No			190	Each	20.0000	1.0000			
												
Bracket												



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	20	
35455	20	

35455 

D3550-1RevB		Manufactured	No			190	Each	31.0000	1.0000			
												
Strut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	31	
36226	5	
45570	6	
48367	20	

45570 1P 8/9/22

D3552-7RevD		Manufactured	No			190	Each	16.0000	1.0000			
												
Door Prop												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	16	
32644	16	

32644 1P 8/9/22

Picklist Print

Page 17

July 1, 2009 8:46:22 AM

Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350

Start Date: 07/15/2009

Required Date: 08/03/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S D3554-7RevA		Manufactured	No			190	Each	81.0000	1.0000			
---------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Ball Stud

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

81

37674

81

S AN960JD516

Purchased

No

190

Each

1,603.000 2.0000



Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1603

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

296

112082

1000

37674 1x 10

111279 3x 12/1/22 (2)

July 1, 2009 8:46:22 AM

Shop Packet Print

Page 17

Picklist Print

July 1, 2009 8:46:22 AM

Work Order ID: 48151

Parent Item: D350-600-241RevC

Parent Item Name: Spacepod, LH, AS350



Comments:

Start Date: 07/15/2009

Required Date: 08/03/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3015-3RevB		Manufactured	No			190	Each	435.0000	1.0000			
												
Locknut												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	435	
43758	26	
44446	50	
48238	359	

48238 1x 7/22/09

Date: Friday, 22/05/2009 4:44:10 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number : 48151	
Estimate Number : 12775	
P.O. Number :	Part Number : D350600241
This Issue : 22/05/2009 S.O. No. :	Drawing Number : IIN REV.C PG11,18-21
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 47001	Material :
Written By :	Due Date : 26/06/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.05.25</u>	
Comment : Est Rev:A 07.03.07 new issue ec	
est rev B 07.04.16 reformat,D3188 revE ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

✓ DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-241 CHG001

2.0

✓ 48151A

SPACEPOD BODY LH

**Comment:** Sub-Component SPACEPOD BODY LH

1 x D3188-1M Batch

3.0

✓ 48151B

SPACEPOD DOOR LH

**Comment:** Sub-Component SPACEPOD DOOR LH

1 x D3186-3 Batch

4.0

✓ D31871

Spacepod Floor

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1

Floor

5.0

✓ ALS41032130

Insert

**Comment:** Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

insert

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 ✓ A3235020935 Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

7.0 ✓ SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Drill holes in D3188-1 using drill jig DT8970
- 2-Open holes in D3188-1 body floor to Ø0.297" as per dwg D3188
- 3-Deburr
- 4-Install inserts in D3188-1 as per Dwg D3188.

8.0 ✓ QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 ✓ D29861 Rubber Spacer



Comment: Qty.: 1.0500 Each(s)/Unit Total : 1.0500 Each(s)

neoprene foam

batch: _____

10.0 ✓ SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Cut D2986 Neoprene Foam per template D2986T1

11.0 ✓ D30153 Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lock Nut

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

✓ D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BALL STUD

batch: _____

13.0

✓ D35671

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: _____

14.0

✓ AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

BATCH: _____

15.0

✓ D2237

Striker Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

16.0

✓ MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Batch: _____

17.0

✓ D35381

Hinge Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HINGE BRACKET

batch: _____

18.0

✓ D2179

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0



AN526C832R24

screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

batch: _____

20.0



AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

21.0



MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

batch: _____

22.0



SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

this step seperates hardware, previous steps is for body & floor*

23.0



MS270390811

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

24.0



AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: _____

25.0



NAS1515H3

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #: Machine Or Operation: Description :

26.0 ✓ MS21042L08

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

27.0 ✓ D2464

3/4 Seal



Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s)

3/4 Seal

Cut 127.00" long batch: _____

28.0 ✓ D35671

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

DECAL

batch: _____

29.0 ✓ D2586

Door Latch



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Door Latch

batch: _____

30.0 ✓ D2585

Mounting Channel



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Clamp

batch: _____

31.0 ✓ D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Latch Plate

batch: _____

32.0 ✓ MS27039115

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0



AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch: _____

34.0



MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

batch: _____

35.0



D28571

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

36.0



D28572

Hinge Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hinge Bracket

batch: _____

37.0



D2228

Bracket Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Backing Plate

batch: _____

38.0



AN526C832R10

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch: _____

39.0



AN960JD8

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS21042L08

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

batch: _____

41.0

D35571

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

42.0

AN526C832R14

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

43.0

AN526C832R10

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

batch: _____

44.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-3 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight

A/R Hysol batch: _____ expire date: _____

A/R Milled fibres batch: _____

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement Batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

45.0

QC5

INSPECT WORK TO CURRENT STEP

160



Comment: INSPECT WORK TO CURRENT STEP

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

170



Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: _____

47.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

180



Comment: Inspect Wing Walk

48.0

K10021

Spacepod Hardware Kit (-241)



Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s)

49.0

D350600449

Switch Relocation



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SWITCH RELOCATION KIT

50.0

D2985

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Label

51.0

D35471

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET

batch: _____

52.0

D35501

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

STRUT

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:44:10 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 48151

Part Number: D350600241

Job Number:



Seq. #:

Machine Or Operation:

Description :

53.0



D35527

Gas Spring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CARBON STEEL GAS SPRING

batch: _____

54.0



D35547

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD

batch: _____

55.0



AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

batch: _____

56.0



D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut

batch: _____

57.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

58.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-600-141

Location: _____

PPP Rev: _____

59.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

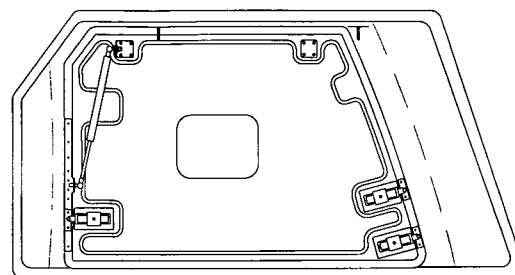
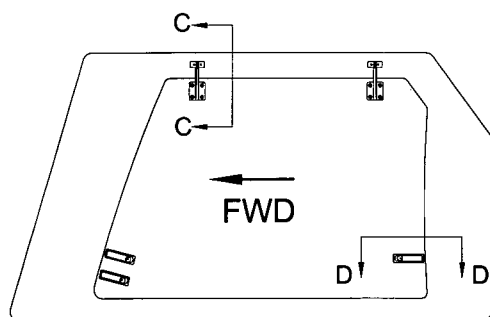


FIGURE 6(a). -141 SPACEPOD KIT (-142 OPPOSITE, -143 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)

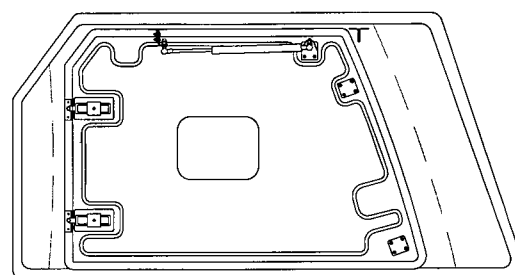
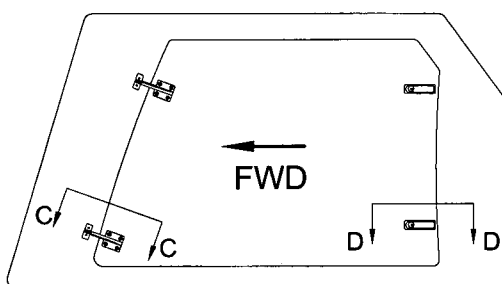
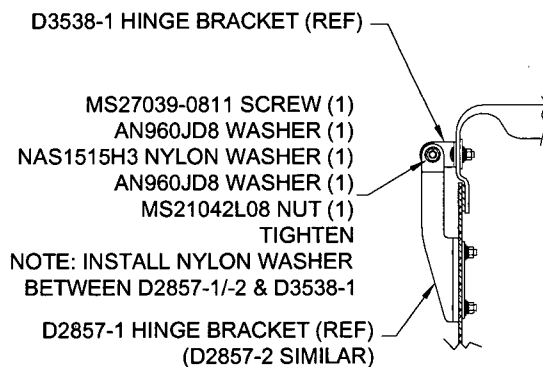
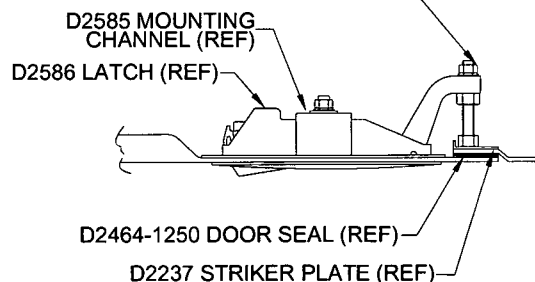


FIGURE 6(b). -241 SPACEPOD KITS (-242 OPPOSITE, -243 SIMILAR)
(OUTSIDE VIEW SHOWN ON LEFT; INSIDE VIEW SHOWN ON RIGHT)



ADJUST SCREW TO ENSURE
COMPRESSION OF DOOR SEAL
AND LOCK IN POSITION WITH NUT



SECTION 'C-C' HINGE
(-141 SHOWN; -142/-143/-241/-242/-243 SIMILAR)

SECTION 'D-D' LATCH

3.2.12 Re-install the following components that were removed from the aircraft in earlier steps:

- Re-install the battery shelf cover or wiring cover per the Aircraft Maintenance Manual. If it is necessary to trim the lower edge to clear the pod floor, touch up the paint using MIL-C-85285 polyurethane paint.
- If applicable, re-install the pop-out float cylinders per the Aircraft Maintenance Manual.
- Re-install the belly panel per the Aircraft Maintenance Manual.

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- 3.4.5 After the paint has dried, apply the D2464-1250 neoprene seal where removed in earlier steps.
- 3.4.6 Cut out the rectangular section shown in Figures 14(a) and 14(b). Install the D2586 latch, D2588 mounting channel and D2621 latch plate that were removed earlier from the door using new hardware as shown in Figure 14(c).

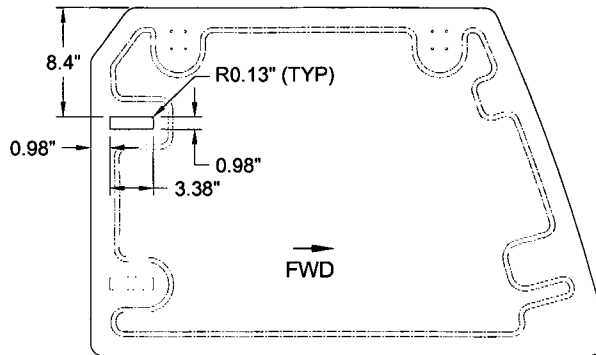


FIGURE 14(a). D3186-1 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -041/-043/-141/-143 KITS)

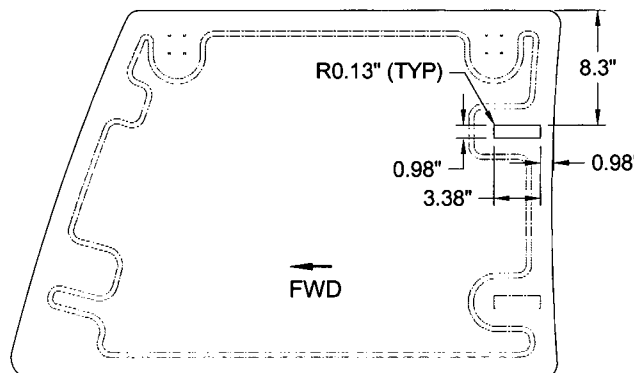


FIGURE 14(b). D3186-2 SPACEPOD DOOR LATCH CUTOUT
(APPLICABLE FOR -042/-142 KITS)

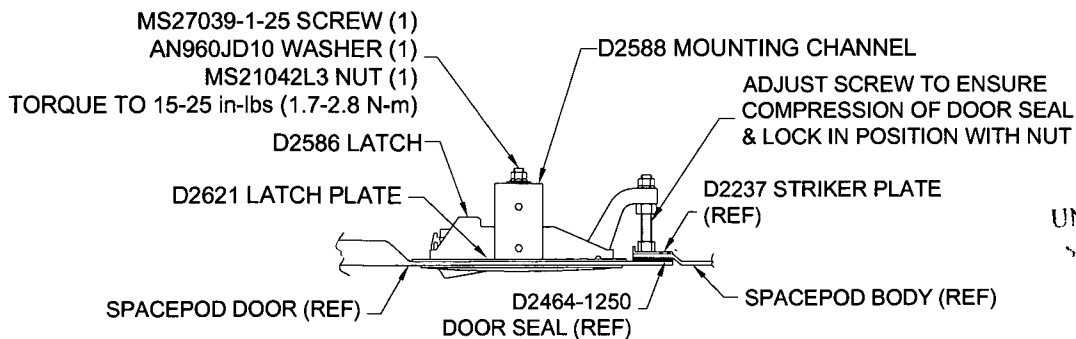


FIGURE 14(c). LATCH INSTALLATION
(SHOWN WITH DOOR INSTALLED ON POD)

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- 3.4.7 Position the D2857-1/-2 hinge brackets as shown in Figure 15(a) for the LH side and Figure 15(b) for the RH side. Transfer drill the Ø0.172" mounting holes on each bracket to the **Spacepod™** door. Install the hinge brackets as shown in Section J-J.

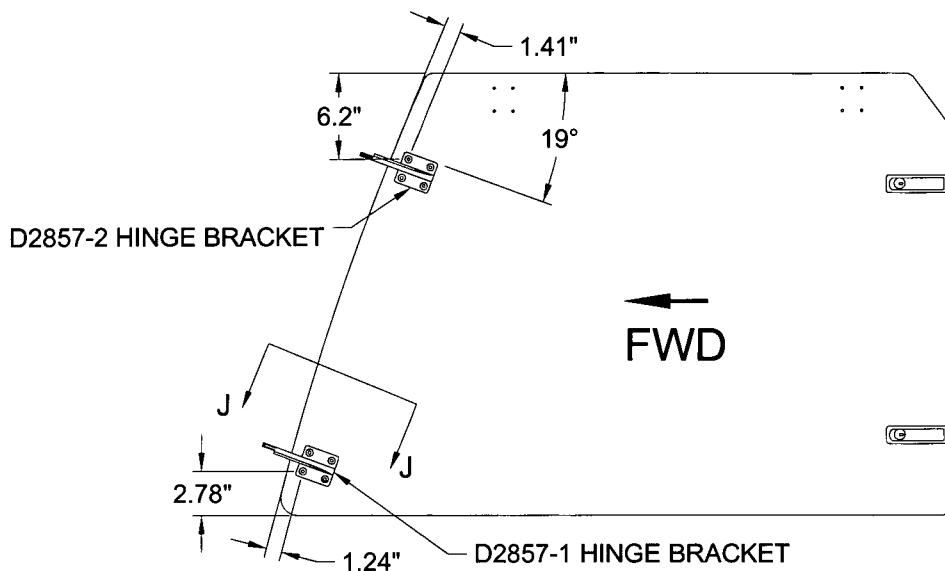


FIGURE 15(a). HINGE BRACKET POSITION ON LH D3186-1 SPACEPOD DOOR

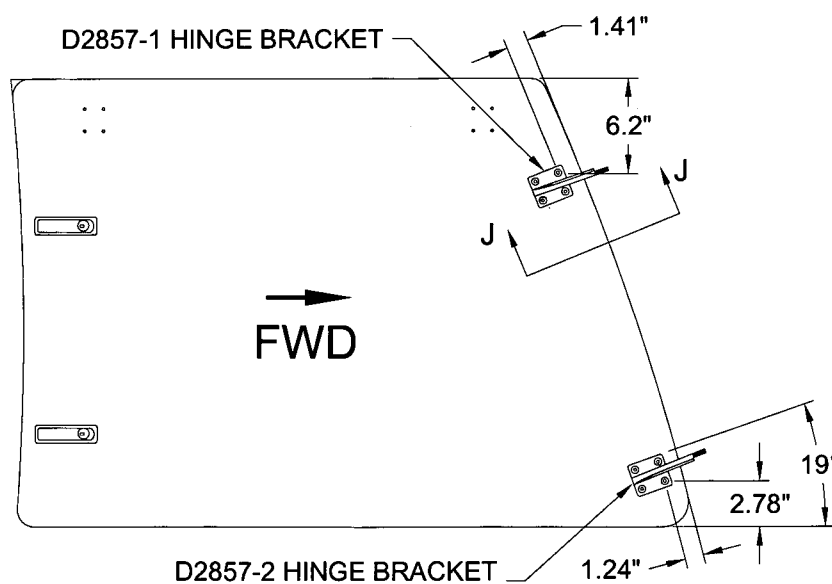
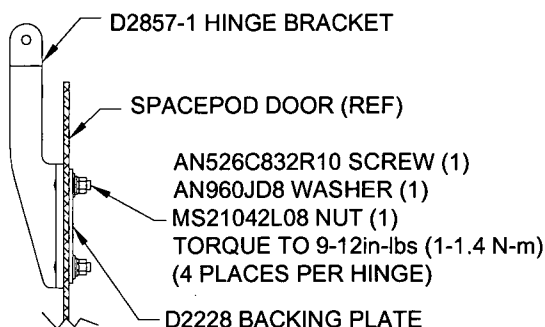


FIGURE 15(b). HINGE BRACKET POSITION ON RH D3186-2 SPACEPOD DOOR

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SECTION 'J-J' HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 SIMILAR)

- 3.4.8 Install the D3557-1 bracket in the existing forward hinge mounting holes with the D2228 backing plates and the D3554-7 ball stud as shown in Figure 16.

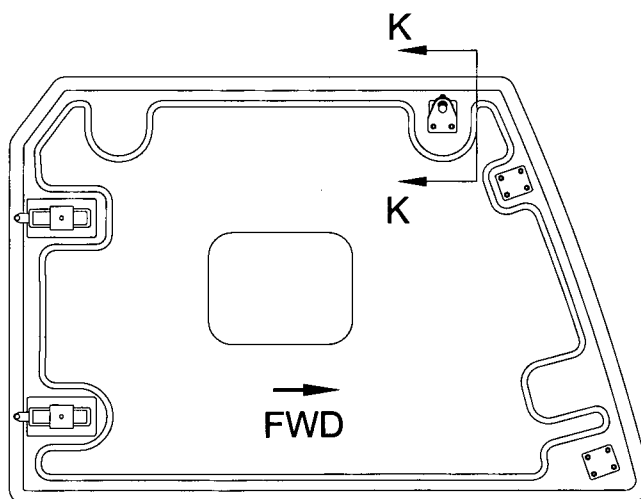
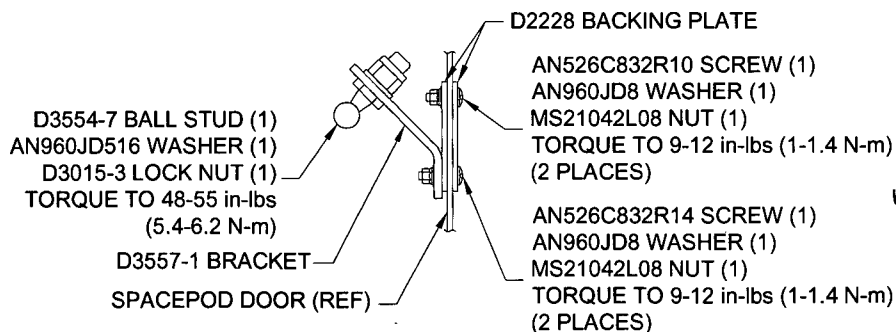


FIGURE 16. BRACKET AND BALL STUD INSTALLATION ON SPACEPOD DOOR
(INSIDE OF D3186-1 SHOWN; D3186-2 OPPOSITE)



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SECTION 'K-K'

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 Date: 07.02.20

- 3.4.9 Install the hinge brackets on the pod as shown in Figures 17(a) and 17(b):
- Assemble the D3538-1 hinge brackets with the D2857-1/-2 hinge brackets as shown in Figure 17(b). Position the door on the pod and transfer mark the mounting holes from the D3538-1 hinge brackets to the **Spacepod™** body.
 - Remove the door and drill $\varnothing 0.375$ " holes where marked. Remove the foam inner layer 0.250" around the hole between the inner and outer skins as shown in Figure 17(a).
 - Apply tape or an equivalent backer to the inner side of the holes to prevent epoxy filler from going through. Fill the cavity between the skins completely with Hysol 934NA mixed with milled glass fibers to in a ratio of 10:1 or Metalset A4. Allow the material to cure.
 - Reposition the **Spacepod™** door and hinges and transfer drill the $\varnothing 0.172$ " D3538-1 hinge bracket mounting holes to the pod.
 - Install the hinge brackets and **Spacepod™** door as shown in Figure 17(b).

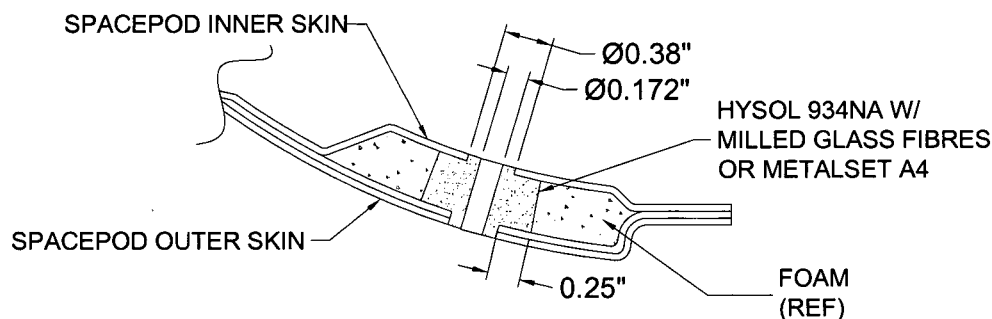


FIGURE 17(a). COMPOSITE MODIFICATION

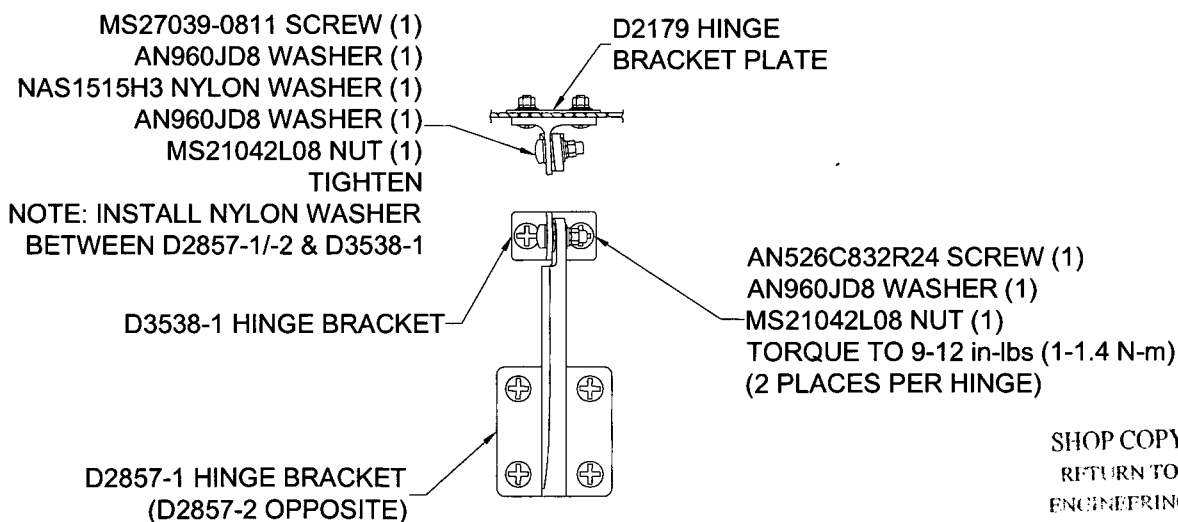


FIGURE 17(b). HINGE BRACKET INSTALLATION
(D2857-1 SHOWN; D2857-2 OPPOSITE)

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